



# Selectarc HRT60

*Tubular Electrode  
For hardfacing  
(mineral abrasion)*

## Description & Applications

Tubular electrode filled with chromium carbide powder. Deposit highly resistant to abrasion and mineral erosion. High amount of Cr carbides in an austenitic matrix, very compact. To consume with very low current. Agreeable melting. No slag. Deposit not machinable. Possibility to increase deposition by introducing a second electrode in the arc (double the recommended current). Surfacing of all austenitic and Mn steels types, grey cast iron (without any preheating), tool steels or high alloyed steels (in this case, carry out a cushion layer with Selectarc 29/9 or 18/8Mn electrodes).

**General applications:** For agriculture, cement industries, quarries, brickyards, civil engineering, for screws of brick press, for excavating jars,...

## All Weld Metal Mechanical Properties

Hardness (1<sup>st</sup> layer)  
55-60 HRC

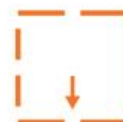
Hardness (2<sup>nd</sup> layer)  
58-62 HRC

## Welding Current & Instructions

Electrode	ØxL ( mm )	6x450	8x450	12x450
Current	( A )	80-120	120-180	210-250

Maintain an arc length of 2 to 5 mm, weave with the electrodes. Hold the electrode perpendicularly to the surface. Do not apply more than 2 or 3 layers.

ind.13



= + ~ 45V

**Liability:** This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.